

Process Sheet

SP/17

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	MOUNTING LUG
Job Number	33249	Part Number	D32351
Estimate Number	10428	Drawing Number	D3235 REV A
P.O. Number	N/A	Project Number	N/A
This Issue	6/28/2007	S.O. No.	N/A
Prsh Rev.	NC	Drawing Revision	A
First Issue	N/A	Material	N/A
Previous Run	30996	Due Date	7/25/2007
Written By	D7.06.28		
Checked & Approved By			
Comment	Est A 04.04.19 New issue KJ/JLM		

Additional Product

Job Number



Seq. #:	Machine Or Operation:	Description :
1.)	D2423	Lug Extrusion 
		Comment: Qty.: 0.0717 f(s)/Unit Total : 35.8575 f(s) Lug Extrusion D2423 extrusion Batch: 30062
2.)	BAND SAW	BAND SAW 
		Comment: Band Saw Cut D2423 extrusion to 0.820" Batch: <i>issue: P/O: 4091 C207/07/04 (500)</i>
3.)	HAAS1	HAAS CNC VERTICAL MACHINING #1 
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Follo FA369 and Dwg D3235 2-Identify as D3235-1 3-Deburr and Tumble Receiving: <i>7/8/08/08</i>  <i>(200) 1/8/15 300x50</i>
4.)	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>N/A</i>
5.)	QC5	SECOND CHECK <i>06/01/09 En 07/08/17 X300</i> 
		Comment: SECOND CHECK Do a check and inspect for transit damage. <i>W 07/08/13 (200)</i>

Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 33249

Part Number: D32351

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(300X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-J 07/08/14

07-08-14

200

7.0 QC5



INSPECT WORK TO CURRENT STEP



(300 counters)

Comment: INSPECT WORK TO CURRENT STEP

En 07/08/14

(x200)

8.0 POWDER COATING



POWDER COATING

En fail



07/08/23

(200)

(300)

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

BL/M-J 07/08-15

9.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION

En fail



(300)

Comment: INSPECT POWDER COAT

10.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

07-08-25

300

Location: _____

11.0 QC21

FINAL INSPECTION/W/O RELEASE



(300)

Comment: FINAL INSPECTION/W/O RELEASE

P. 07/08/17

07-08-17

Job Completion



U

DART AEROSPACE LTD	Work Order:	33249
Description: Mounting Lug	Part Number:	D3235-1
Inspection Dwg: D3235 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

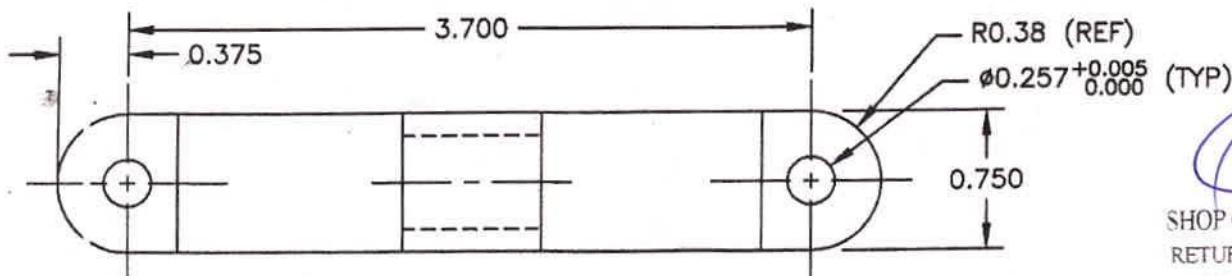
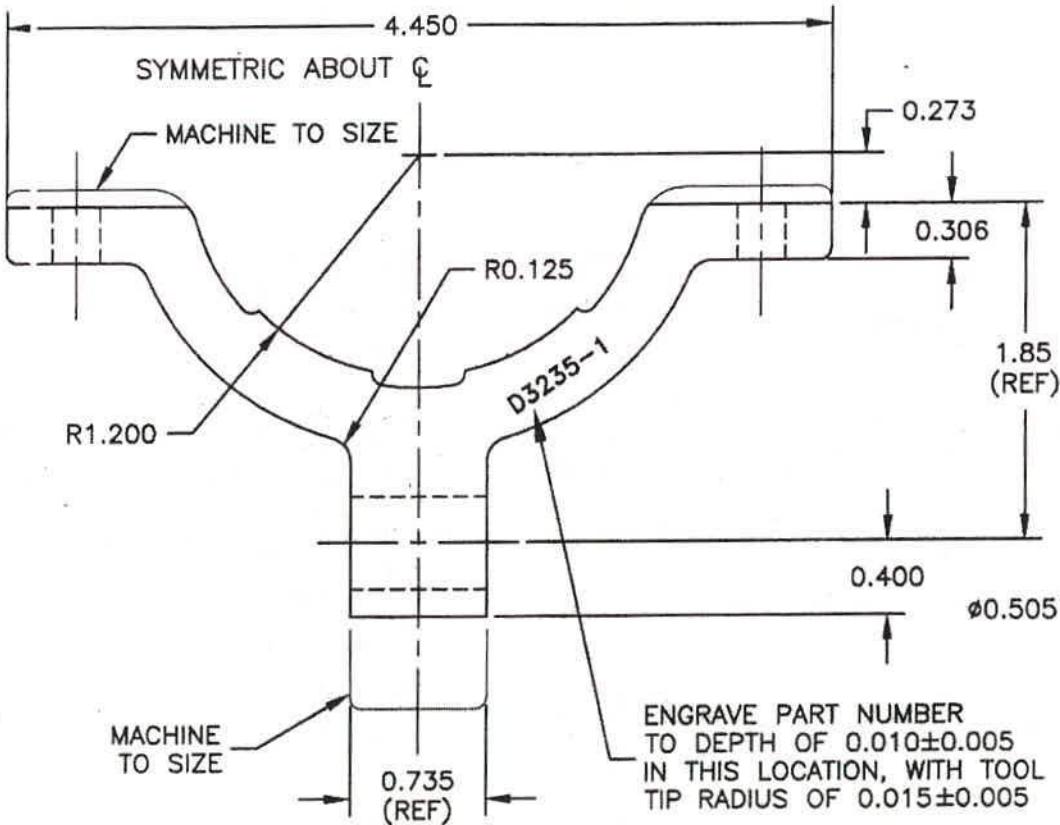
X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	JUL

DART

DESIGN	GP	DRAWN BY	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. A
				D3235	SHEET 1 OF 1
DATE				TITLE	SCALE
04.03.02				MOUNTING LUG	1:1
A	04.03.02			NEW ISSUE	

RELEASED
04.04.05 off**D3235-1 MOUNTING LUG**

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000–0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 33249



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
300	D3235-1	Mounting Lug B33249	4091

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shig Walz".

Shig Walz

Vankleek Hill, August 15, 2007

NETEC METAL TECHNOLOGY INC.

Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 16093
Date: Aug 15, 2007
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 4091	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date:

	Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1	Mounting Lug	Each	500		
MATERIAL 2423 B30062 supplied by DART					
D3235-1	Mounting Lug ✓	Each	500	300	
D3338-1	Mounting Lug	Each	20		
D3394-3	Lug	Each	40		

1/8/15

Received by _____

Thank you for your order!